

Date: Monday, 5/15/2006 10:50:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L HIGH GEAR SKIDTUBE
Job Number	: 27096A		
Estimate Number	: 10522		
P.O. Number	: N/A	Part Number	: D206642441
This Issue	: 5/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2650 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27095A	Drawing Revision	: E
		Material	: N/A
Written By	: <u>SEK COMMENT Below</u>	Due Date	: 6/2/2006
Checked & Approved By	: <u>KT 06-05-18</u>	Qty:	1 Um: Each
Comment	: Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

KT 06-05-18

2.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	227205 BE 06-06-14

3.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	224842 BE 06-06-14

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

BE 06-06-14

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

BE 06-06-14

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m100660/m18839 BE 06-06-14

4-Grind weld flush to cap on top surface only.

BE 06-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 27096A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

BE 06-06-14

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BE 06-06-15

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 06-06-19

6.0

D26547

206 I Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

527107

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

IT 06-06-19

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

IT 06-06-19

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

IT 06-06-19

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: *060619* Time: *1100*

Finish Date: *060620*

Time: *7100*

IT 06-06-19

A/R Sikaflex-291

7101126

Sikaflex expiry date:

06-11-01

W/O:		WORK ORDER CHANGES					
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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



DP06-6-20



Comment: INSPECT WORK TO CURRENT STEP

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B23864 BE0606-20

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M18239 BE06-06-20

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

BE06-06-27

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

BE06-06-27

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B24203 BE06-06-27

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

M18548 BE06-06-27

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Job Number: 27096A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M19099 BE 06-06-27

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

BE 06-06-27

15.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC9 -> DD 06-06-27 (1)

BE 06-27 (1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

SC 07/04/06

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/07/04 (1)

18.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B 25904

19.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B 24845

DL

(1)

SC 06/07/05

W/O:		WORK ORDER CHANGES					
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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe B 24846

21.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe B 23558

22.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad B 24417

23.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts M 1829B

or (see QSI 017)

24.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer M 18235

2C

1

W/O:		WORK ORDER CHANGES					
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Job Number: 27096A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw M 18836

26.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs B 25144

27.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings B 25978

28.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer M 11151

29.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw M 6874

DV
JC 06/07/05

W/O:		WORK ORDER CHANGES					
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Job Number: 27096A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B25381

31.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

M18235

32.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

M18836

SC 06/07/06
DL

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M101193

Sikaflex expiry date:

11/06

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M101193

Sikaflex expiry date:

11/06

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M101246

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PS Date: 06/07/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:50:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 27096A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

AL 06/07/07 (1)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock:

Location: _____

NA 06/07/11

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/07/10 (1)

Job Completion



W 06/07/10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DARTRELEASED
16 04 17 #

DESIGN <i>1/P</i>	DRAWN BY <i>1/P</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET



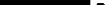


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
- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

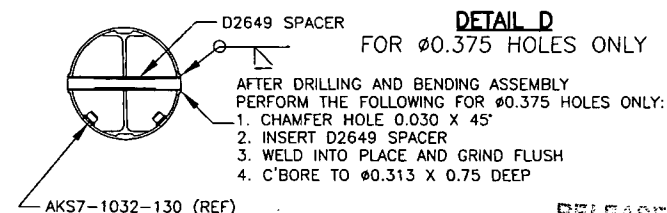
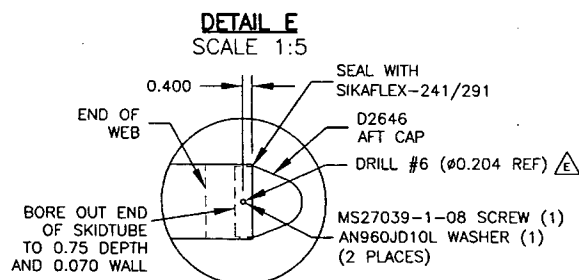
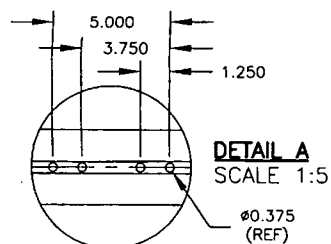
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WITHOUT NOTICEWORK ORDER
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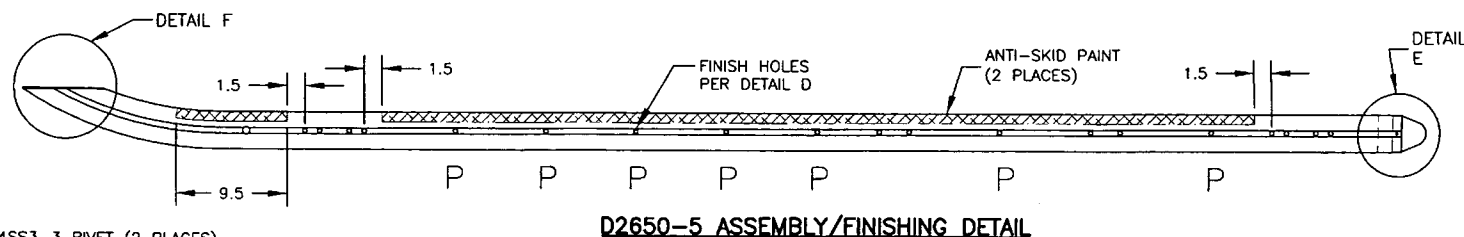
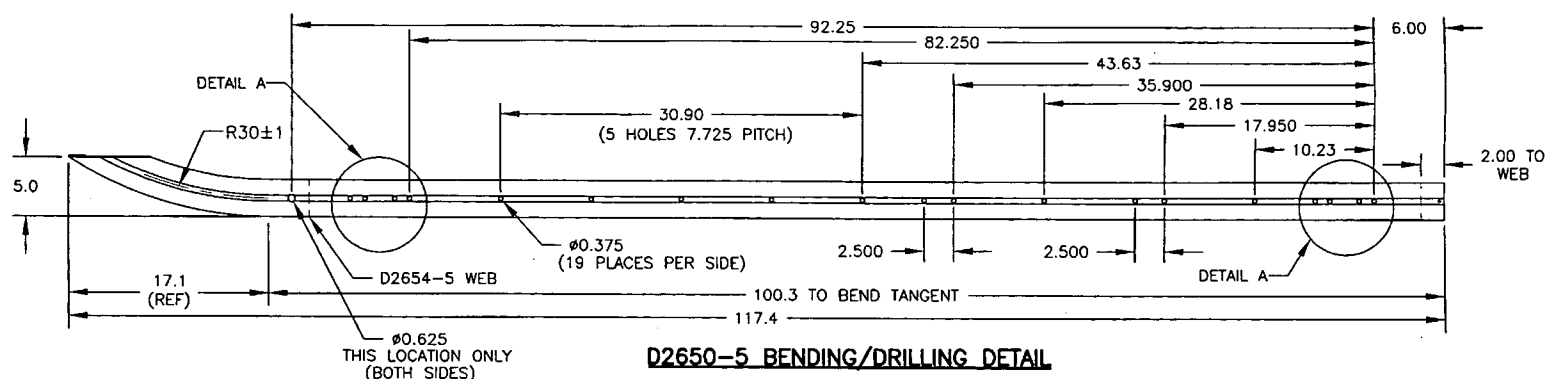
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	CHECKED 	APPROVED 	DRAWING NO. D2650
	DATE 06.03.30	TITLE SKIDTUBE	

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	CHECKED	APPROVED		DRAWING NO.	REV. E
	DATE			TITLE	SHEET 3 OF 5
					SCALE
					1:10
	UP	UP			
	PH	AF	D2650		
	06.03.30		SKIDTUBE		



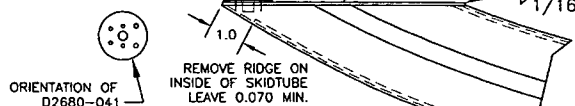
RELEASED



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27096A

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